Type 874-CL
LOCKING CABLE CONNECTOR*

(U. S. Patent No. 2,548,457)

Remove cable jacket and insulation to expose braid and inner conductor to dimensions shown in Figure 1.

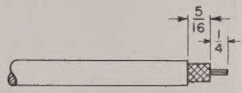

Figure 1.

Slip on cord guard (874-71; see Figure 2) using talc if necessary, locking nut (874-6177), coupling nut (874-6179), and ferrule (FEC-3). Insert inner transition piece (874-64) through the end of the outer transition piece (874-63) and slip inner transition piece over inner cable conductor until the end touches cable insulation; then solder. Install snap rings (874-81) in both grooves. Slide outer transition piece onto cable under braid and jacket as far as possible.

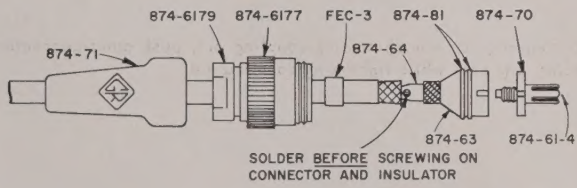

Figure 2.

Insert inner connector (874-61-4) in insulator (874-70) and thread into inner transition piece, holding the hex-shaped part with a wrench.[1,2] CAUTION: Insulator will melt if the inner connector and insulator are screwed on before the cable is soldered.

Slide outer transition piece up to the insulator. Align keyways. Slip outer connector (874-60-3; see Figure 3) over insulator and outer transition piece so that keys engage keyways. With outer connector (874-60-3) seated on the first snap ring, tighten and arrange cable braid over small end of outer transition piece (874-63). Cover with ferrule (FEC-3) and crimp in place. To crimp, use a Type 874-TO58 Crimping Tool or hold ferrule against a sturdy surface and pinch and push simultaneously with a pair of gas pliers as shown in Figure 3. The Crimping Tool is recommended for large-quantity operations or where the neatest crimp is desired. To use this tool, disengage ratchet lock by squeezing the handles together,

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*For use with General Radio Type 874-A2 Cable.

[1]The Type 874-TOK Tool Kit is recommended for assembly of all Type 874 Connectors. This kit consists of a Type 874-TO117 inner-connector wrench, a Type 874-TO115 outer-connector wrench, and a Type 874-TO116 coupling-nut wrench.

[2]To install inner connector and insulator in rigid line or inner transition piece using tools: insert inner connector into insulator and push assembly into the end of the inner-connector wrench, observing alignment of keys and keyways. Thread assembly into the rod or inner transition piece.

carefully position the ferrule in the largest (0.375-inch) die, and squeeze the handles together until the ratchet lock releases.

Be sure that the outer connector (874-60-3; see Figure 3) is seated when the crimp is made.

Screw coupling nut (874-6179; see Figure 2) on outer connector and tighten until nut bottoms firmly.[3] Thread on locking nut (874-6177). Stretch rubber cord guard (874-71) over coupling nut (874-6179) and seat lip in groove provided.

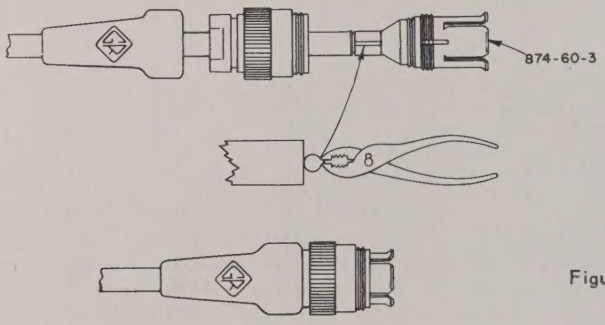

Figure 3.

[3]Clamp coupling-nut wrench on ring coupling nut, push outer-connector wrench onto outer connector, and hold while tightening coupling nut.

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